

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004613**Date Inspected:** 07-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Fabrication				

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Heavy Bay #3

This QA Inspector performed random final visual inspections of the closed rib stiffener welds of deck panels DP166-001, DP605-001, DP382-001 and DP301-001. The QA Inspector observed ZPMC and ABF representatives had completed visual inspections of these welds and they had identified the welds of these deck panels are acceptable on the yellow inspection status tag that is attached to each of the deck panels. The QA Inspector identified two locations where weld overlap had not been previously removed. Following rework, items observed appear to comply with project specifications. The QA Inspector documented the final visual inspections on the yellow inspection status tags that are attached to the deck panels.

The QA Inspector performed initial random visual inspections of closed rib stiffener welds of deck panels DP090-001, DP117-001 and DP117-002. The QA Inspector observed ZPMC and ABF representatives had completed visual inspections of these welds and they had identified portions of the welds that need rework. The initial inspections have been documented on the bottom of the yellow inspection status tag that is attached to each of the deck panels. Prior to QA performing visual inspections of these welds, ZPMC ultrasonic inspectors had performed ultrasonic inspections of portions of the stiffener plate welds and the ultrasonic couplant they had left

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on the weld surfaces had not completely dried resulting in parts of the welds being partially obscured due to this couplant. The QA Inspector informed ABF representative Mr. Wang Zhong Yuan that the welds were not clean and dry and Mr. Wang Zhong Yuan had ZPMC personnel use rags and an air hose to remove couplant and dry the weld surfaces. Following this cleaning the QA Inspector completed the initial visual inspections of the welds on all three of these deck panels. The QA Inspector documented the initial visual inspections on the bottom of the yellow inspection status tags that are attached to each of the deck panels.

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
